

Work Order ID 86427

June-28-12 1:01:51 PM

86427

Page 1

Item ID: D3889-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Panel, Floor

Start Date: 28/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/28 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3889	A					②			

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3889-1

Lexa grey Y8

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B12-7-6

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-7-L

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check 0.00

120

QC

Memo

0.00

Quality Control

8/7/12

②

130 0.00

130

Small Fab

Memo

0.00

Small Fab

Deburr if necessary

1/5

140 Pick Kit 0.00

140

Packaging

Memo

0.00

Packaging

24

9/12/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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June-28-12 1:01:51 PM

Page 3

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 28/06/2012 **Start Qty:** 2.00

2

Customer:

Required Date: 12/07/2012 **Req'd Qty:** 2.00

2

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

150

0.00

150

Small Fab

Memo

0.00

Small Fab

1- Bond gasket to smooth side of panel as per dwg
A/R 3M 1300 adhesive Batch: 47122211

A/R 3M 1300 adhesive Batch: M12234

160

QC5- Inspect part completeness to step on W/O	0.00
---	------

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 0.00

0.00

170

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
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June-28-12 1:01:51 PM

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Page 4

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Item Name: Panel, Floor

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Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/7/24 *[Signature]*
MF
12-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June-28-12 1:01:55 PM

Page 1

Work Order ID: 86427

86427

Parent Item: D3889-041

D3889-041

Parent Item Name: Panel, Floor

Start Date: 28/06/2012

Required Date: 12/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,636.106	8.1925	17.24737	8		
MI FXS 125-F60029-04									**			1312-7-6	
GE PLASTICS LEXAN SHEET													

Location	Loc Qty	Loc Code
MAT018	1503	
121803	1503	
MAT019	133.1064	
119937	133.1064	

D3889-3 Manufactured No

D3889-3

Gasket

Location	Loc Qty	Loc Code
ST242	1	
81017	1	

119937

2

**

8/2/07/23

386428

(K)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	86427
Description: Panel		Part Number:	D3889-1
Inspection Dwg: D3889 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.88	+/-0.030	1.89	V		T B01	
34.0	+/-0.100	34.0	✓		T	
27.35	+/-0.030	27.35	✓		T	
8.37	+/-0.030	8.37	✓		T	
25.35	+/-0.030	25.35	✓		T	
27.77	+/-0.030	27.77	✓		T	
34.7	+/-0.100	34.7	✓		T	
14.30	+/-0.030	14.30	✓		T	
20.56	+/-0.030	20.56	✓		T	
24.02	+/-0.030	24.02	✓		T	
23.23	+/-0.030	23.23	✓		T	
0.125	+/-0.010	0.130	✓		V B02	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 12-7-6	Date: 17/6/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	P/O D3889-041 KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

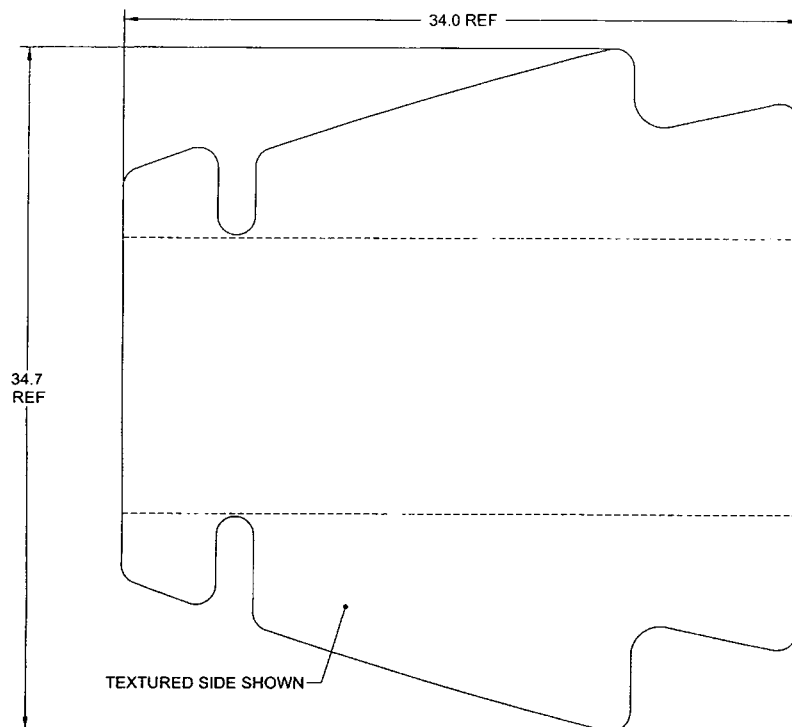
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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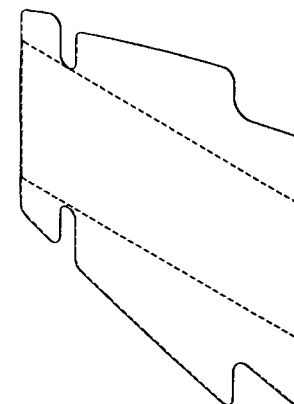
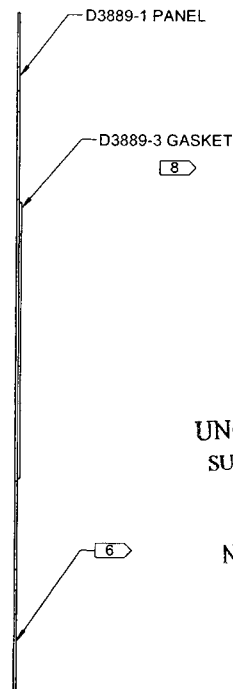
PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3889-041	PANEL, FLOOR
2	1	D3889-1	PANEL
3	1	D3889-3	GASKET
4	A/R	3M 1300	ADHESIVE

**D3889-041 PANEL, FLOOR**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3889-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 5.13 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86427 MLJ

12/06/28

RELEASED
9/6/15 N/P

A	NEW ISSUE	CP	09.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.20		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3889	REV. A
TITLE PANEL, FLOOR	SHEET 1 OF 3
SCALE NTS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

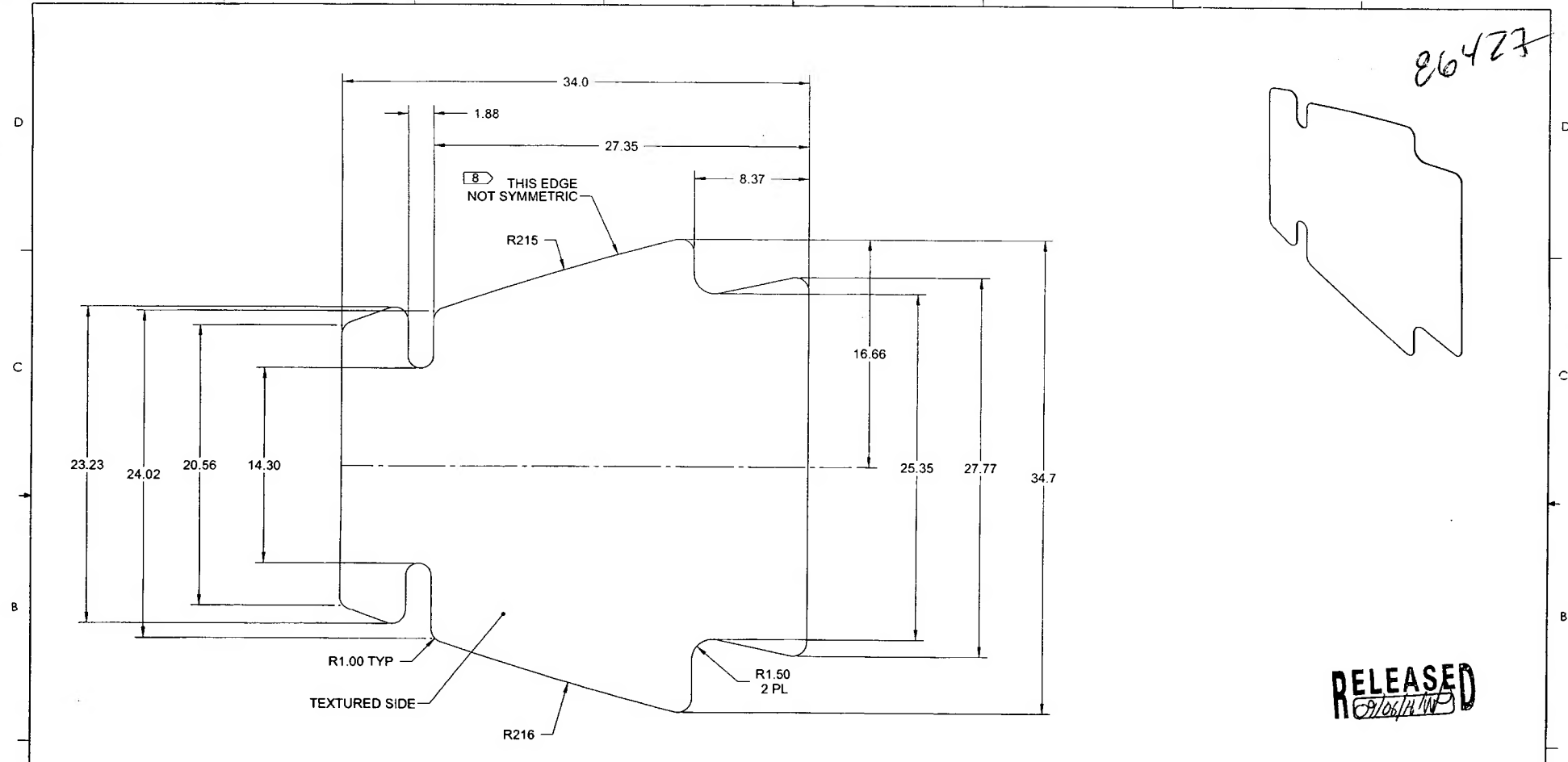
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

86427



D3889-1 PANEL

NOTES:

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.95 lbs
- 8) PART SYMMETRIC ABOUT CENTERLINE EXCEPT AS SHOWN

RELEASED
09/04/20

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	D3889	SHEET 2 OF 3
APPROVED	92	TITLE	SCALE
DE APPR.	92	PANEL, FLOOR	NTS
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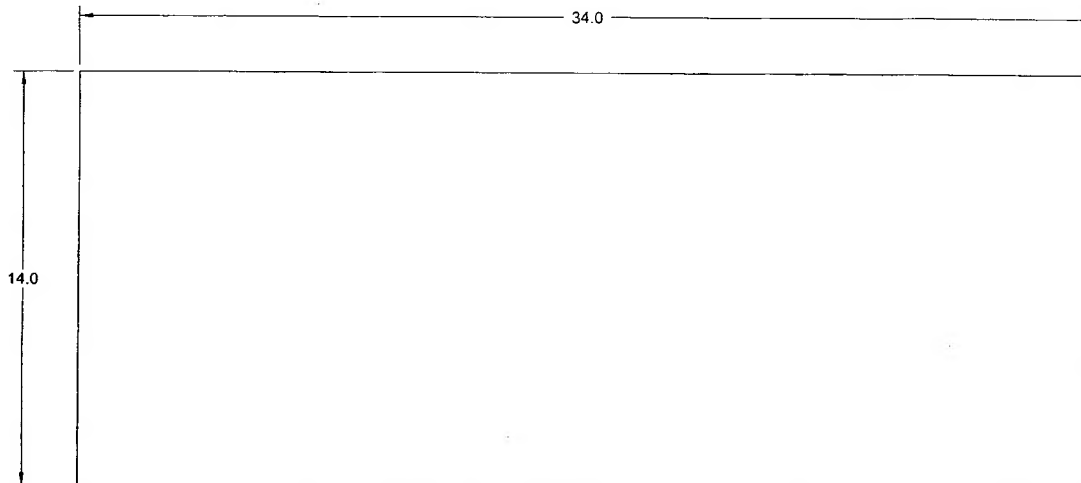
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NOTE: Date & initial all entries

26427



D3889-3 GASKET

RELEASED
09/06/16 JH

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3889	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PANEL, FLOOR	NTS
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